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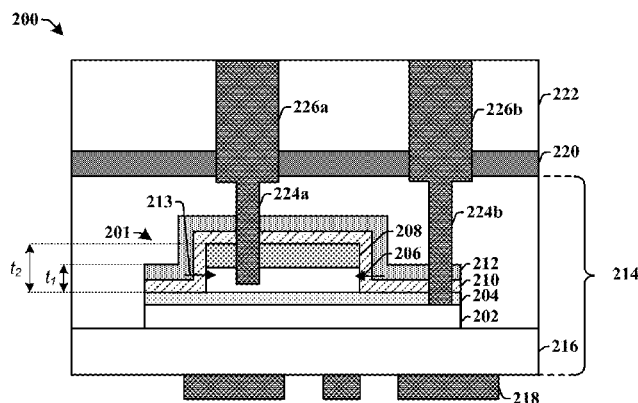
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- (57) **ABSTRACT**

- The present disclosure relates to method of forming a MIM (metal-insulator-metal) structure having a buffer cap layer that reduces stress induced by an overlying stress-inducing protective layer, and an associated apparatus. The method is performed by forming a lower conductive layer over a semiconductor substrate, forming a dielectric layer over the lower conductive layer, and forming an upper conductive layer over the dielectric layer. A buffer cap layer is formed over the upper conductive layer and a stress-inducing protective layer is formed onto the buffer cap layer. The buffer cap layer reduces a stress induced onto the upper conductive layer by the stress-inducing protective layer, thereby reducing leakage current between the lower and upper conductive layers.

- 20 Claims, 6 Drawing Sheets**

- (58) **Field of Classification Search**
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H01L 28/60; H01L 28/65; H01L 28/90;
H01L 45/085; H01L 45/1233; H01L 45/143;
H01L 45/1683



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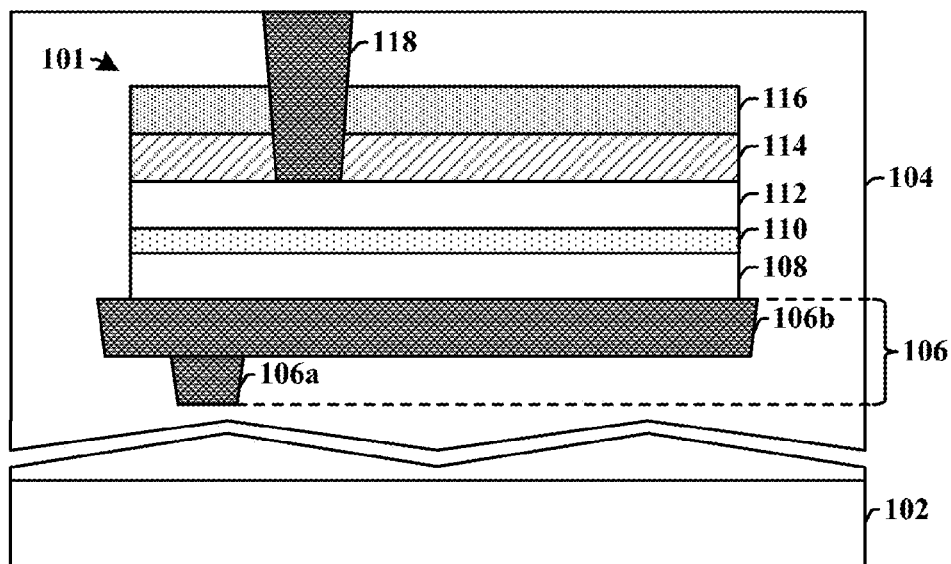


Fig. 1

200

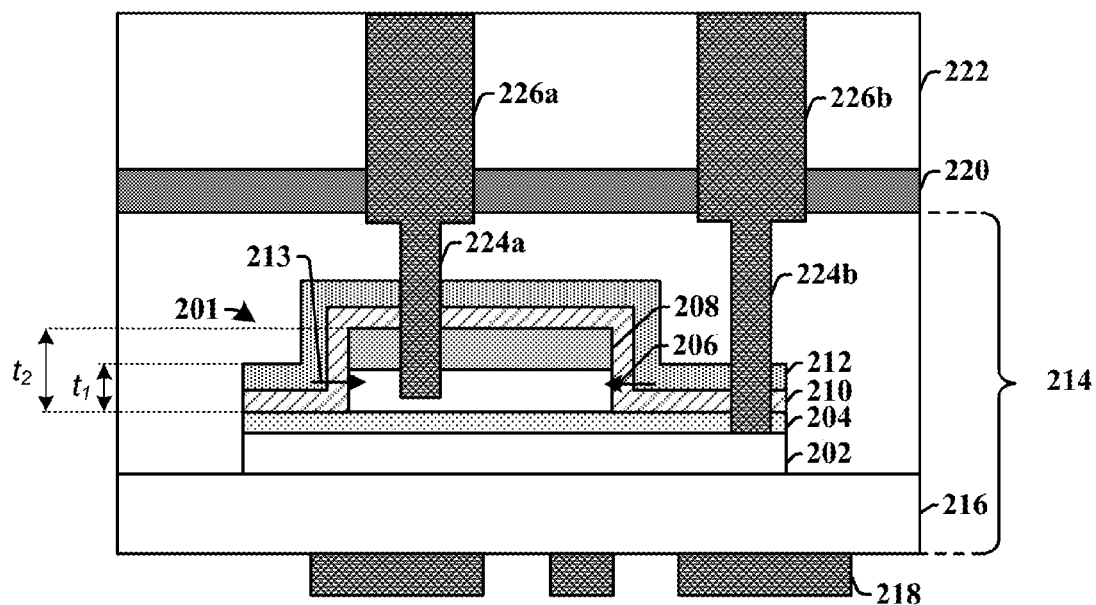


Fig. 2

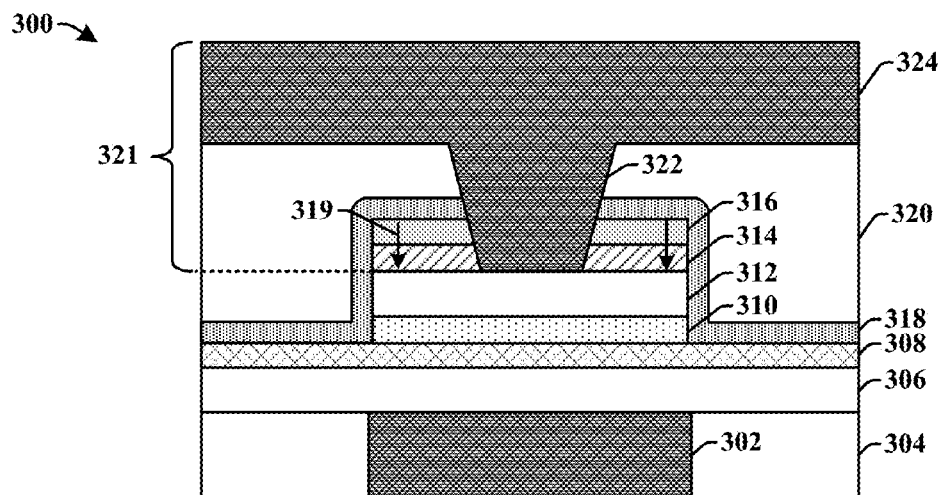


Fig. 3

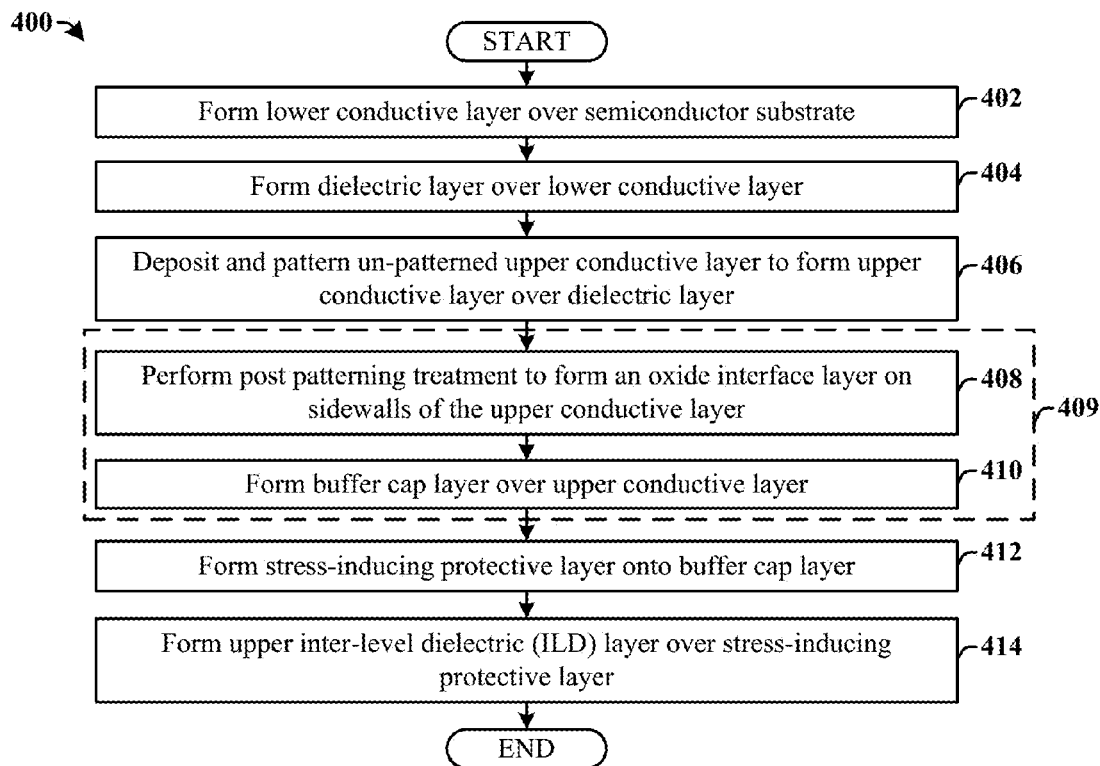
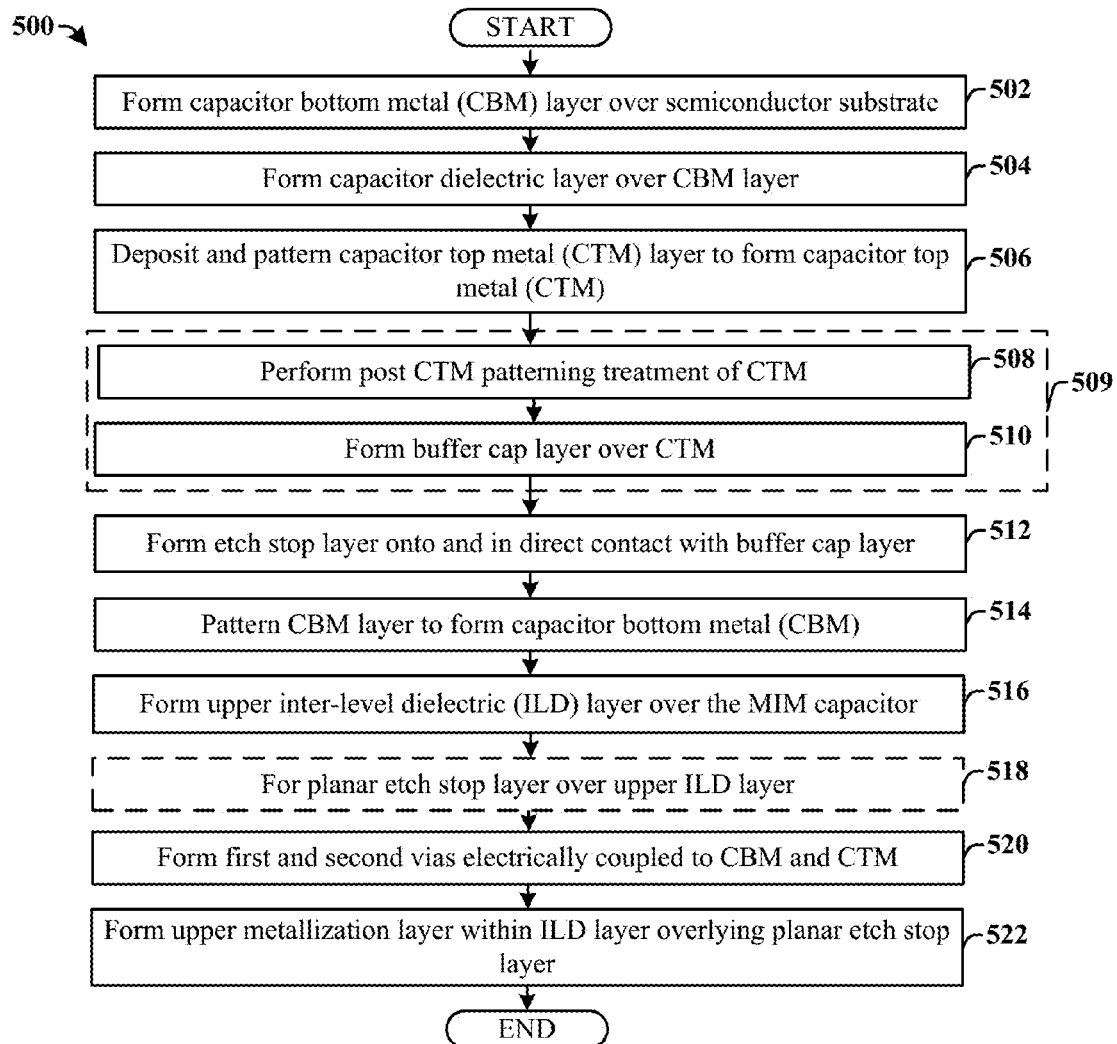
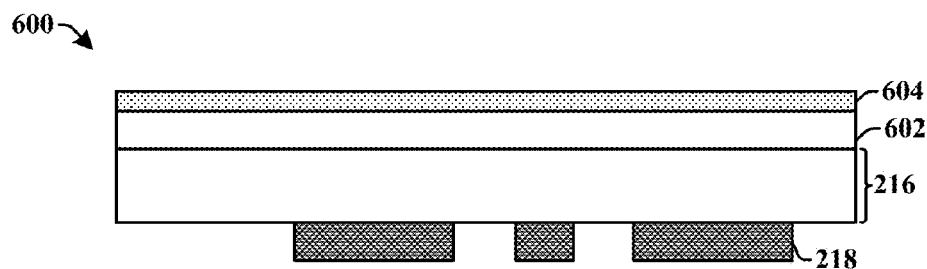


Fig. 4

**Fig. 5****Fig. 6**

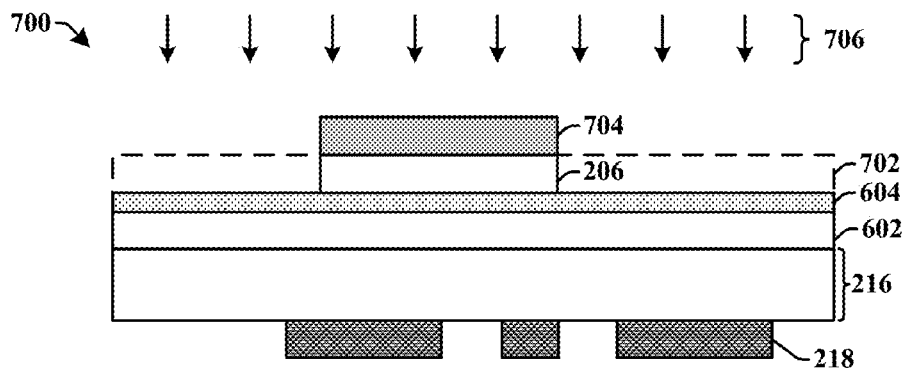


Fig. 7

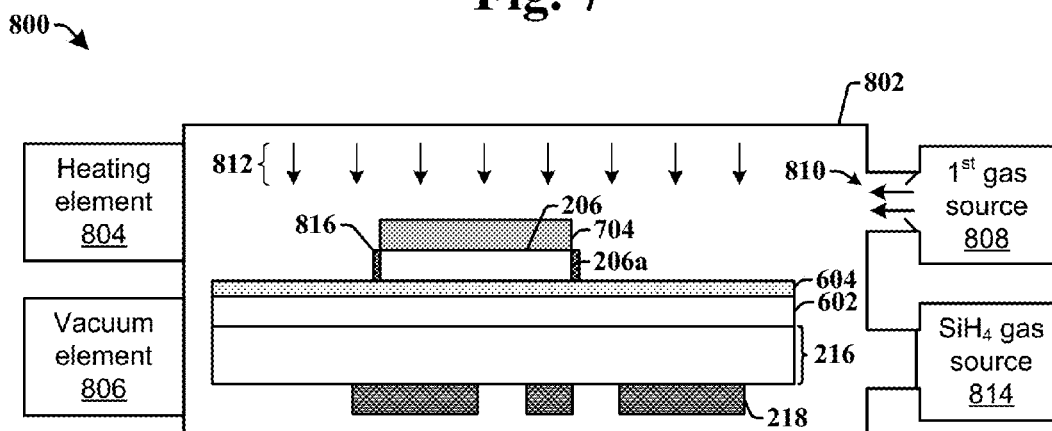


Fig. 8

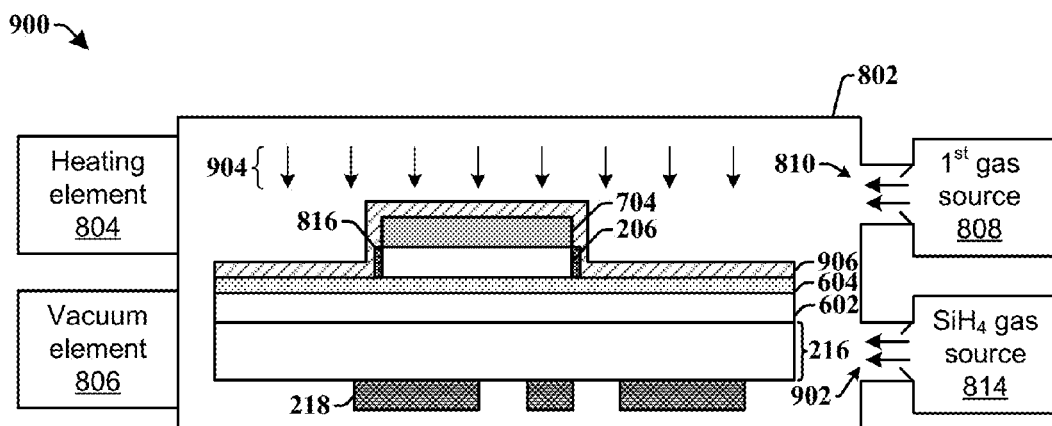


Fig. 9

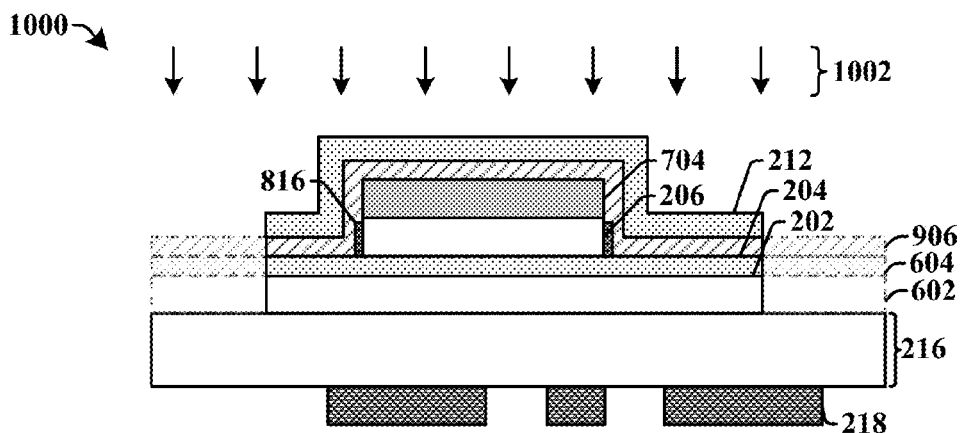


Fig. 10

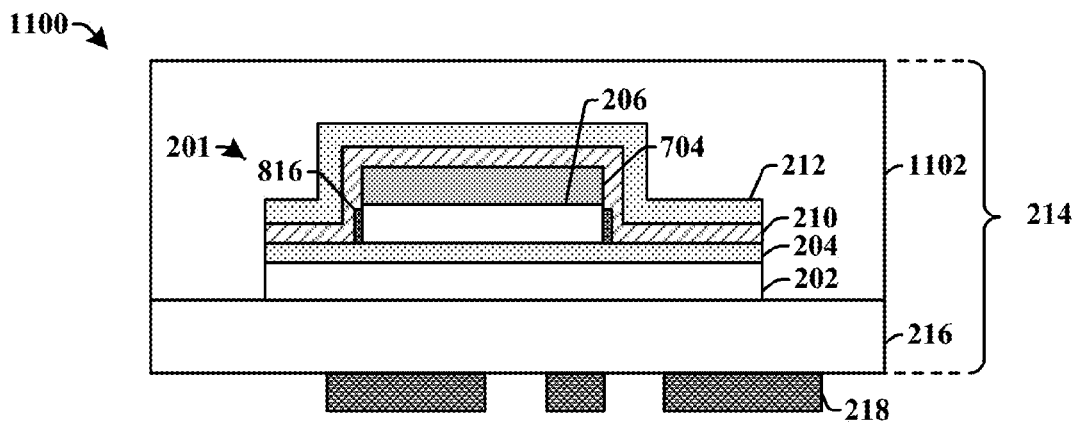


Fig. 11

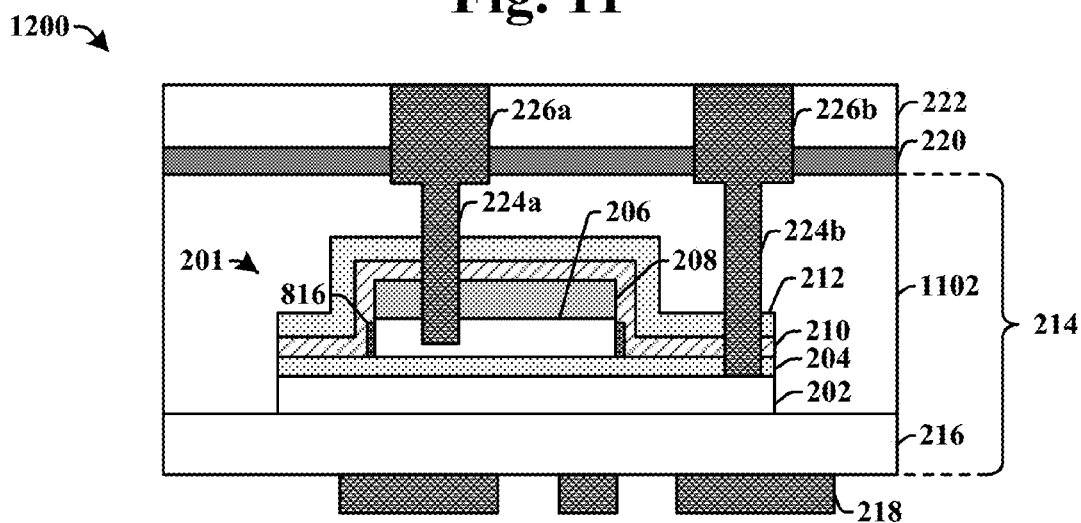


Fig. 12

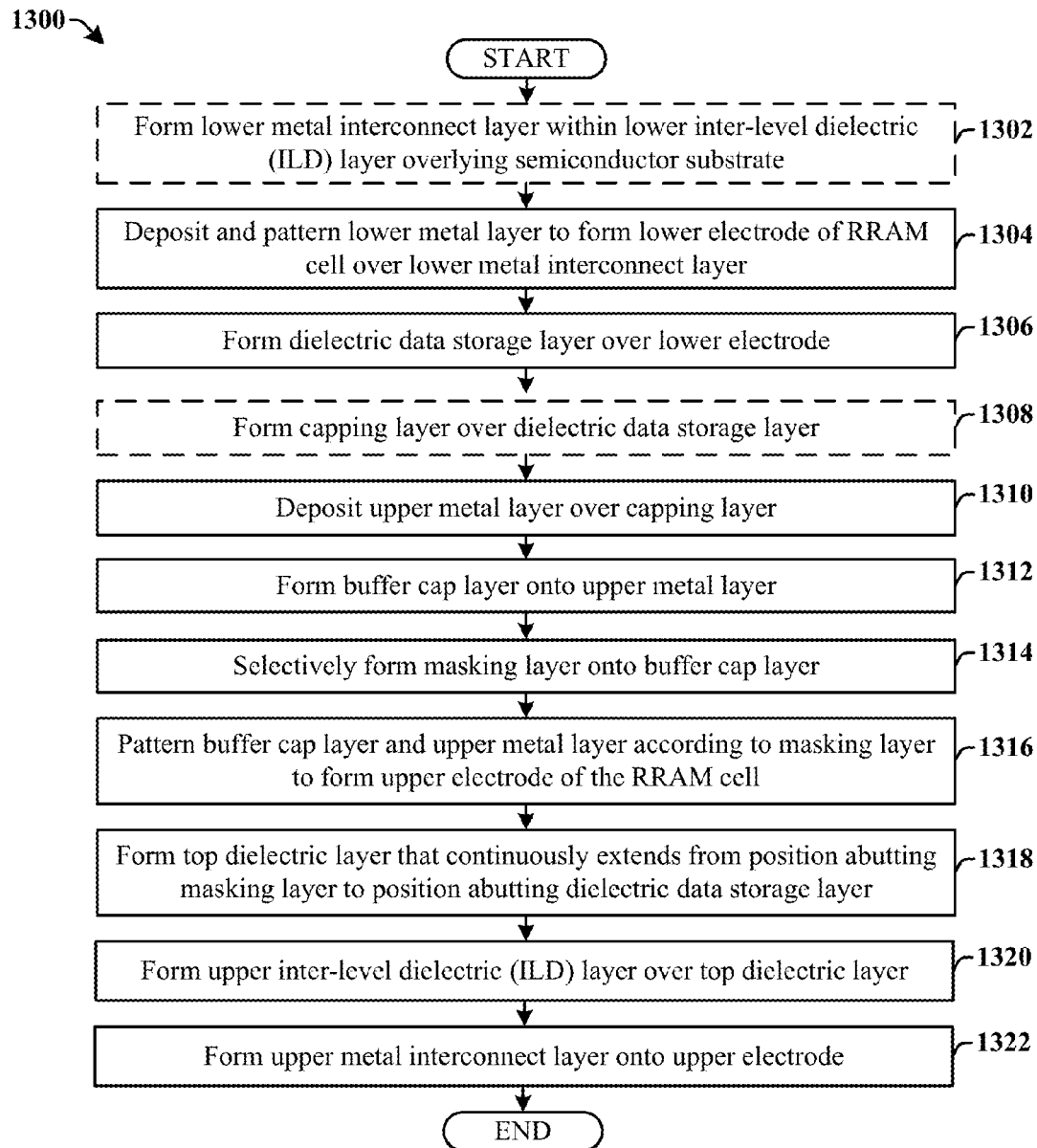


Fig. 13

BUFFER CAP LAYER TO IMPROVE MIM STRUCTURE PERFORMANCE

BACKGROUND

Metal-insulator metal (MIM) structures comprise an insulating layer disposed between conductive layers (e.g., metal layers). The conductive metal layers have free charge carriers (e.g., holes and/or electrons) that allow for electrical charge to easily travel, while the insulating layer does not have free charge carriers. MIM structures are found in a wide range of applications in modern day integrated chips. For example, MIM structures may be used in passive devices such as MIM capacitors or in memory devices such as resistive random access memory (RRAM) cells. More recent developments have also proposed the use of MIM structures in other applications, such as in diodes and waveguides, for example.

BRIEF DESCRIPTION OF THE DRAWINGS

Aspects of the present disclosure are best understood from the following detailed description when read with the accompanying figures. It is noted that, in accordance with the standard practice in the industry, various features are not drawn to scale. In fact, the dimensions of the various features may be arbitrarily increased or reduced for clarity of discussion.

FIG. 1 illustrates a cross-sectional view of some embodiments of an integrated chip having a MIM (metal-insulator-metal) structure comprising a buffer cap layer configured to reduce leakage between conductive layers.

FIG. 2 illustrates a cross-sectional view of some embodiments of an integrated chip comprising a MIM capacitor having a buffer cap layer.

FIG. 3 illustrates a cross-sectional view of some embodiments of an integrated chip comprising a resistive random access memory (RRAM) cell having a buffer cap layer.

FIG. 4 illustrates a flow diagram of some embodiments of a method of forming an integrated chip comprising a MIM structure having a buffer cap layer.

FIG. 5 illustrates a flow diagram of some embodiments of a method of forming an MIM structure comprising a MIM capacitor having a buffer cap layer.

FIGS. 6-12 illustrate some embodiments of cross-sectional views showing a method of forming a MIM capacitor having a buffer cap layer.

FIG. 13 illustrates a flow diagram of some embodiments of a method of forming an MIM structure comprising a RRAM cell having a buffer cap layer.

DETAILED DESCRIPTION

The following disclosure provides many different embodiments, or examples, for implementing different features of the provided subject matter. Specific examples of components and arrangements are described below to simplify the present disclosure. These are, of course, merely examples and are not intended to be limiting. For example, the formation of a first feature over or on a second feature in the description that follows may include embodiments in which the first and second features are formed in direct contact, and may also include embodiments in which additional features may be formed between the first and second features, such that the first and second features may not be in direct contact. In addition, the present disclosure may repeat reference numerals and/or letters in the various examples. This repetition is for

the purpose of simplicity and clarity and does not in itself dictate a relationship between the various embodiments and/or configurations discussed.

Further, spatially relative terms, such as “beneath,” “below,” “lower,” “above,” “upper” and the like, may be used herein for ease of description to describe one element or feature’s relationship to another element(s) or feature(s) as illustrated in the figures. The spatially relative terms are intended to encompass different orientations of the device in use or operation in addition to the orientation depicted in the figures. The apparatus may be otherwise oriented (rotated 90 degrees or at other orientations) and the spatially relative descriptors used herein may likewise be interpreted accordingly.

One type of commonly used MIM (metal-insulator-metal) structure is a MIM capacitor. A MIM capacitor has a capacitor top metal (CTM) and a capacitor bottom metal (CBM) separated by a layer of dielectric material. A MIM capacitor may often be integrated into a back-end-of-the-line (BEOL) metallization stack of an integrated chip, at a position that is vertically disposed between an underlying first metal layer and an overlying second metal layer.

MIM capacitors are typically covered with a silicon nitride film formed by a PE-CVD deposition (PE-SiN layer) process. The PE-SiN film is configured to act as an etch stop layer that protects the MIM capacitor during subsequent processing. As the size of MIM capacitors decreases, the relative thickness of the PE-SiN film has increased. However, it has been appreciated that as the thickness of the PE-SiN film increases, a compressive stress generated by the PE-SiN film also increase. The compressive stress acts upon corners of the CTM, causing the corners to bend downward and thereby increasing leakage current between the CTM and CBM.

Accordingly, the present disclosure relates to a method of forming a MIM (metal-insulator-metal) structure having a buffer cap layer that is configured to reduce stress induced by an overlying stress-inducing protective layer, and an associated apparatus. In some embodiments, the method is performed by forming a lower conductive layer over a semiconductor substrate, forming a dielectric layer over the lower conductive layer, and forming an upper conductive layer over the dielectric layer. A buffer cap layer is formed over the upper conductive layer and a stress-inducing protective layer is formed onto the buffer cap layer. The buffer cap layer is configured to reduce a stress induced onto the upper conductive layer by the stress-inducing protective layer, thereby reducing leakage current between the lower and upper conductive layers.

FIG. 1 illustrates a cross-sectional view of some embodiments of an integrated chip **100** having a MIM (metal-insulator-metal) structure **101**.

The MIM structure **101** is disposed within a dielectric material **104** located over a semiconductor substrate **102**. In various embodiments, the MIM structure may comprise a MIM capacitor, a resistive random access memory (RRAM) cell, a MIM diode, or a MIM waveguide, for example. The MIM structure **101** comprises a lower conductive layer **108** (e.g., a bottom metal layer). In some embodiments, the lower conductive layer **108** may be positioned over one or more lower metal interconnect layers **106** (e.g., a metal via **106a** and/or a metal wire **106b**). A dielectric layer **110** is located over the lower conductive layer **108**. In some embodiments, the dielectric layer **110** may comprise a high-k dielectric layer (i.e., a dielectric layer having a dielectric constant that is greater than that of silicon dioxide). In other embodiments, the dielectric layer **110** may comprise a dielectric data storage layer having a variable resistance. An upper conductive layer

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112 (e.g., an upper metal layer) is positioned over the dielectric layer 110, and an overlying metal interconnect layer 118 (e.g., a via) is disposed onto the upper conductive layer 112.

A buffer cap layer 114 is disposed over the upper conductive layer 112, and a stress-inducing protective layer 116 is disposed over the buffer cap layer 114 in a manner such that the buffer cap layer 114 separates the upper conductive layer 112 from the stress-inducing protective layer 116. The buffer cap layer 114 is configured to reduce a stress (e.g., a compressive stress) induced onto the upper conductive layer 112 by the stress-inducing protective layer 116. Reducing a stress induced onto the upper conductive layer 112 by the stress-inducing protective layer 116 reduces a leakage current between the upper conductive layer 112 and the lower conductive layer 108, thereby improving performance of the disclosed MIM structure 101. In some embodiments, the buffer cap layer 114 may comprise an oxide layer (e.g., an un-doped silicate glass (USG)) and the stress-inducing protective layer 116 may comprise a silicon nitride film (a PE-SiN layer) or a silicon oxy-nitride film (PE-SiON layer) formed by a PE-CVD (plasma enhanced chemical vapor deposition) process.

As provided herein, the disclosed MIM structure (e.g., MIM structure 101) may comprise any type of device that has a stress-inducing protective layer (e.g., a PE-SiN layer, a PE-SiON layer) disposed over a stacked metal-insulator-metal (MIM) structure. For example, FIGS. 2-3 illustrate some embodiments of MIM structures having a disclosed buffer cap layer configured to reduce stress induced onto an upper conductive layer by a stress-inducing protective layer. It will be appreciated that the disclosed MIM structure is not limited to the MIM structures of FIGS. 2-3, but rather that FIGS. 2-3 are merely exemplary MIM structures.

FIG. 2 illustrates a cross-sectional view of some embodiments of an integrated chip 200 having a MIM (metal-insulator-metal) capacitor 201 comprising a stress reducing buffer cap layer.

The MIM capacitor 201 includes a capacitor bottom metal (CBM) 202 (i.e., a bottom electrode) and a capacitor top metal (CTM) 206 (i.e., a top electrode). The CBM 202 and CTM 206 are electrically isolated from one another by a capacitor dielectric layer 204 disposed therebetween. The capacitor dielectric layer 204 is configured to separate the CBM 202 from the CTM 206, so that the MIM capacitor 201 is able to store energy in an electric field generated between the CBM 202 and the CTM 206.

In various embodiments, the CBM 202 and/or the CTM 206 may comprise various conductive materials, such as aluminum (Al), titanium (Ti), titanium nitride (TiN), tantalum (Ta), tantalum nitride (TaN), tungsten (W), copper (Cu), etc. In some embodiments, the capacitor dielectric layer 204 may comprise a high-k dielectric material having a dielectric constant greater than 3.9 (i.e., a dielectric material having a dielectric constant greater than silicon dioxide). In some embodiments, the capacitor dielectric layer 204 may comprise one or more of silicon dioxide (SiO₂), silicon nitride (Si₃N₄), aluminum oxide (Al₂O₃), tantalum oxide (Ta₂O₅), titanium oxide (TiO₂), zirconium oxide (ZrO₂), hafnium oxide (HfO₂), hafnium silicate (HfSiO₄), etc. For example, the capacitor dielectric layer 204 may comprise a ZAZ dielectric film comprising stacked layers of ZrO₂/Al₂O₃/ZrO₂.

A buffer cap layer 210 is disposed onto a masking layer 208 (e.g., a hard mask layer) located over the CTM 206, and an etch stop layer 212 is disposed onto the buffer cap layer 210. The buffer cap layer 210 and the etch stop layer 212 comprise stepped layers having varying heights. The buffer cap layer 210 is disposed onto the masking layer 208 and the capacitor

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dielectric layer 204, and abuts sidewalls of the CTM 206 and the masking layer 208. The etch stop layer 212 is configured to induce a compressive stress 213 that pushes laterally on the CTM 206. The buffer cap layer 210 is configured to mitigate the compressive stress 213 pushing on the CTM 206, so as to reduce leakage between the CTM 206 and the capacitor bottom metal layer 202. In some embodiments, the buffer cap layer 210 and the etch stop layer 212 may have a first thickness t_1 that is less than a second thickness t_2 of the CTM 206 and the masking layer 208.

In some embodiments, the capacitor ILD layer 214 may extend below the CBM 202 as a dielectric buffer layer 216. In various embodiments, the dielectric buffer layer 216 may have a thickness that is in a range of between approximately 5% and approximately 50% of the thickness of the capacitor ILD layer 214. In such embodiments, the dielectric buffer layer 216 will protect the MIM capacitor 201 from hillocks (i.e., spike or hill-like structures) protruding from an under-metal layer 218 comprising one or more metal structures.

In some embodiments, a planar etch stop layer 220 is disposed over the capacitor ILD layer 214. The planar etch stop layer 220 has a planar surface disposed between a metal wire layer 226 and a plurality of metal vias 224. The metal wire layer 226 comprises a conductive material (e.g., copper, aluminum, etc.) disposed within a metal ILD layer 222 and configured to provide for lateral interconnections. The plurality of metal vias 224 are configured to provide for vertical interconnections between the MIM capacitor 201 and the metal wire layer 226.

FIG. 3 illustrates a cross-sectional view of some embodiments of RRAM (resistive random access memory) cell 300 having a stress reducing buffer cap layer.

RRAM cell 300 comprises a dielectric data storage layer 308 disposed between a bottom electrode 306 and a top electrode 312. The bottom electrode 306 is located over a lower metal interconnect layer 302 surrounded by lower inter-level dielectric (ILD) layer 304. In some embodiments, the lower metal interconnect layer 302 may comprise one of a plurality of metal interconnect layers located between the bottom electrode 306 and an underlying semiconductor substrate (not shown).

The dielectric data storage layer 308 has a variable resistance, which depending on an applied voltage, will undergo a reversible change between a high resistance state associated with a first data state (e.g., a '0') and a low resistance state associated with a second data state (e.g., a '1'). For example, a voltage applied to the dielectric data storage layer 308 will induce conductive paths (e.g., oxygen vacancies) to form across the dielectric data storage layer 308, thereby reducing the resistance of the dielectric data storage layer 308. In some embodiments, a capping layer 310 may be disposed over the dielectric data storage layer 308. The capping layer 310 is configured to store oxygen, which can facilitate resistance changes within the dielectric data storage layer 308. In some embodiments, the capping layer 310 may comprise a metal or a metal oxide that is relatively low in oxygen concentration.

A buffer cap layer 314 is disposed over the top electrode 312. The buffer cap layer 314 has sidewalls that are aligned with sidewalls of the top electrode 312. The buffer cap layer 314 may comprise planar layer that is disposed between the top electrode 312 and an overlying masking layer 316 (e.g., a hard mask layer). In some embodiments, the masking layer 316 may comprise a silicon oxy-nitride (SiON) hard mask layer, a silicon dioxide (SiO₂) hard mask layer, or a PE-SiN hard mask. The masking layer 316 is configured to induce a stress 319 that pushes on the top electrode 312. The buffer cap

layer **210** is configured to mitigate the stress **319**, so as to reduce leakage current between the top electrode **312** and the bottom electrode **306**.

In some embodiments, a top dielectric layer **318** may be disposed onto the masking layer **316**. The top dielectric layer **318** may continuously extend along sidewalls of the capping layer **310**, the top electrode **312**, the buffer cap layer **314**, and the masking layer **316**. The top dielectric layer **318** separates the capping layer **310**, the top electrode **312**, the buffer cap layer **314**, and the masking layer **316** from an upper inter-level dielectric (ILD) layer **320**, which surrounds an upper metal interconnect layer **321** disposed onto the top electrode **312**. The upper metal interconnect layer **321** comprises the upper metal via **322**, which extends through the masking layer **316** and the buffer cap layer **314**, from the top electrode **312** to an upper metal wire **324**.

FIG. 4 illustrates a flow diagram of some embodiments of a method **400** of forming an integrated chip comprising a MIM structure having a buffer cap layer.

At **402**, a lower conductive layer is formed over a semiconductor substrate.

At **404**, a dielectric layer is formed over the lower conductive layer. In various embodiments, the dielectric layer may comprise a high-k dielectric layer or a dielectric data storage layer having a variable resistance.

At **406**, an un-patterned upper conductive layer is deposited and patterned to form an upper conductive layer over the dielectric layer.

At **408**, a post patterning treatment is performed to form an oxide interface layer on sidewalls of the upper conductive layer. In some embodiments, the post patterning treatment comprises exposing sidewalls of the upper conductive layer to a nitrous oxide (N_2O) gas. The oxide interface layer prevents the presence of a metallic polymer residue on the sidewalls of the upper conductive layer, which can result from patterning (e.g., etching) of the upper conductive layer.

At **410**, a buffer cap layer is formed over the upper conductive layer. In some embodiments, the buffer cap layer may be formed in-situ with the post patterning treatment (shown by box **409**).

At **412**, a stress-inducing protective layer (e.g., a PE-SiN layer or a PE-SiON layer) is formed onto the buffer cap layer. The stress-inducing protective layer is separated from the upper conductive layer by way of the buffer cap layer.

At **414**, an upper inter-level dielectric (ILD) layer is formed over the stress-inducing protective layer.

Although method **400** describes the formation of the lower and upper conductive layers in a sequential manner, it will be appreciated that the method is not limited to such a sequential formation. For example, in some embodiments, the MIM structure may be formed by depositing a stack comprising a lower metal layer and an upper metal layer separated by a dielectric layer. The upper metal layer may subsequently be patterned prior to patterning of the lower metal layer.

FIG. 5 illustrates a flow diagram of some embodiments of a method **500** of forming an MIM structure comprising a MIM capacitor having a buffer cap layer.

While the disclosed methods (e.g., methods **400**, **500**, and **1500**) are illustrated and described herein as a series of acts or events, it will be appreciated that the illustrated ordering of such acts or events are not to be interpreted in a limiting sense. For example, some acts may occur in different orders and/or concurrently with other acts or events apart from those illustrated and/or described herein. In addition, not all illustrated acts may be required to implement one or more aspects or

embodiments of the description herein. Further, one or more of the acts depicted herein may be carried out in one or more separate acts and/or phases.

At **502**, a capacitor bottom metal (CBM) layer is formed over a semiconductor substrate. In some embodiments, the CBM layer may be formed over a dielectric buffer layer overlying an under-metal layer having a metal inter-connect layer within a back-end-of-the-line (BEOL) stack of an integrated chip.

At **504**, a capacitor dielectric layer is formed over the CBM layer. In some embodiments, the capacitor dielectric layer may comprise a high-k dielectric layer.

At **506**, a capacitor top metal (CTM) layer is deposited over the capacitor dielectric layer and patterned to form a capacitor top metal (CTM) (i.e., a capacitor top electrode).

At **508**, a post CTM patterning treatment is performed on the CTM. The post CTM patterning treatment forms a protective oxide interface layer onto sidewalls of the CTM. The protective oxide interface layer prevents the formation of conductive residue onto sidewalls of the CTM during etching (e.g., of the CTM).

At **510**, a buffer cap layer is formed over the CTM. In some embodiments, the buffer cap layer may comprise an oxide layer (e.g., an un-doped silicate glass). In some embodiments, the buffer cap layer may be formed in-situ with the post CTM patterning treatment (shown by box **509**).

At **512**, an etch stop layer is formed onto and in direct contact with the buffer cap layer. In some embodiments, the etch stop layer may comprise a silicon nitride film formed by a PE-CVD deposition (a PE-SiN layer) process or a silicon oxy-nitride film formed by a PE-CVD deposition (a PE-SiON).

At **514**, the CBM layer is patterned to form a CBM (i.e., a capacitor bottom electrode).

At **516**, an upper inter-level dielectric (ILD) layer is formed over the MIM capacitor.

At **518**, a planar etch stop layer may be formed over the upper ILD layer.

At **520**, first and second vias are formed at positions vertically extending through the planar etch stop layer to the CBM and CTM.

At **522**, an upper metallization layer is formed within a metal inter-level dielectric (ILD) layer overlying the planar etch stop layer. The upper metallization layer is electrically connected to the plurality of vias.

FIGS. 6-12 illustrate some embodiments of cross-sectional views showing a method of forming a MIM capacitor having a buffer cap layer. Although FIGS. 6-12 are described in relation to method **500**, it will be appreciated that the structures disclosed in FIGS. 6-12 are not limited to such a method, but instead may stand alone as structures independent of the method.

FIG. 6 illustrates some embodiments of a cross-sectional view **600** corresponding to act **502-504**.

As shown in cross-sectional view **600**, a capacitor bottom metal (CBM) layer **602** is formed. The CBM layer **602** may be deposited by way of a physical vapor deposition (PVD) process. In some embodiments, the CBM layer **602** may comprise titanium nitride (TiN) or tantalum nitride (TaN). In some embodiments, the CBM layer **602** may be deposited over a dielectric buffer layer **216** that overlies an under-metal layer **218**.

As further shown in cross-sectional view **600**, a capacitor dielectric layer **604** is formed over the CBM layer **602**. In some embodiments the capacitor dielectric layer **604** may be formed by an atomic layer deposition (ALD) process to a

thickness in a range of between approximately 50 angstroms and approximately 100 angstroms.

FIG. 7 illustrates some embodiments of a cross-sectional view **700** corresponding to act **506**.

As shown in cross-sectional view **700**, a capacitor top metal (CTM) layer **702** is formed over the capacitor dielectric layer **604**. In some embodiments, the CTM layer **702** may comprise titanium nitride (TiN) or tantalum nitride (TaN), for example. In some embodiments, the CTM layer **702** may be formed by way of a vapor deposition process (e.g., physical vapor deposition, chemical vapor deposition, etc.). A masking layer **704** is selectively formed over a part of the CTM layer **702** to define a capacitor top metal (CTM) **206** (i.e., a top electrode of the MIM capacitor). In some embodiments, the masking layer **704** may comprise a hard mask material. For example, the masking layer **704** may comprise silicon nitride (SiN) or silicon oxy-nitride (SiON).

A top electrode etching process is subsequently performed by selectively exposing the capacitor top metal layer **702** to an etchant **706** in areas not covered by the masking layer **704**. The etchant **706** forms the CTM **206** by removing unmasked areas of the CTM layer **702**. In some embodiments, the etchant **706** may comprise a dry etchant (e.g., a plasma etchant, an RIE etchant, etc.).

FIG. 8 illustrates some embodiments of a cross-sectional view **800** corresponding to act **508**.

As shown in cross-sectional view **800**, a post capacitor top metal (CTM) patterning treatment is performed on the CTM **206**. The post CTM patterning treatment exposes the sidewalls **206a** of the CTM **206** to one or more post CTM treatment agents **812** comprising an oxygen containing gas(es). In some embodiments, the one or more post CTM treatment agents **812** may comprise nitrous-oxide (N_2O).

It has been appreciated that after etching the CTM layer **702**, a metallic polymer residue remains on the sidewalls **206a** of the CTM **206**. The metallic polymer residue causes worse leakage currents in a resulting MIM capacitor. The one or more post CTM treatment agents **812** are configured to form an oxide interface layer **816** onto the sidewalls **206a** of the CTM **206**, which protect the CTM **206** from the metallic polymer residue. In some embodiments, the oxide interface layer **816** may comprise titanium oxide (TiO_x), titanium oxy-nitride (TiON), tantalum oxide (TaO_x), or tantalum oxy-nitride (TaON).

In some embodiments, the post CTM patterning treatment may be performed by providing a semiconductor substrate into a processing chamber **802** coupled to a heating element **804** and a vacuum element **806**. The heating element **804** is configured to increase a temperature of the processing chamber **802**. For example, in some embodiments the heating element **804** may increase a temperature of the processing chamber **802** to a temperature in a range of between approximately 200° C. and approximately 600° C. The vacuum element **806** is configured to generate a low pressure ambient within the processing chamber **802**. For example, in some embodiments the vacuum element **806** may decrease a pressure of the processing chamber **802** to a pressure in a range of between approximately 1 torr and approximately 5 torr.

The processing chamber **802** is connected to a first gas source **808** configured to provide one or more oxygen-containing first gases **810** into the processing chamber **802** and a second gas source **814** configured to selectively provide one or more second gases into the processing chamber **802**. In some embodiments, the first gas source **808** may be configured to provide one or more oxygen-containing first gases **810** comprising nitrous oxide gas (N_2O) into the processing chamber **802**. The nitrous oxide gas (N_2O) acts as a post CTM

treatment agent **812** configured to contact the sidewalls **206a** of the CTM **206** to form the oxide interface layer **816**. In other embodiments, the first gas source **808** may be configured to provide alternative oxygen-containing first gases such as ozone (O_3), water vapor (H_2O), hydrogen peroxide gas (H_2O_2), nitrogen oxide (NO), carbon dioxide (CO_2), etc.

FIG. 9 illustrates some embodiments of a cross-sectional view **900** corresponding to act **510**.

As shown in cross-sectional view **900**, an un-patterned buffer cap layer **906** is formed onto the masking layer **704**. In some embodiments, the un-patterned buffer cap layer **906** may be formed in-situ (act **509**) with the post CTM patterning treatment. For example, after conclusion of the post CTM patterning treatment the second gas source **814** may be configured to introduce one or more additional gases **902** into the processing chamber **802**. For example, in some embodiments during the post CTM patterning treatment the first gas source **808** may introduce nitrous oxide gas (N_2O) into the processing chamber **802**, while during the formation of the un-patterned buffer cap layer **906** the second gas source **814** may additionally introduce silane gas (SiH_4) into the processing chamber **802**. The nitrous oxide gas (N_2O) and the silane gas (SiH_4) collectively act to form the un-patterned buffer cap layer **906** by way of a chemical vapor deposition (CVD) process. In some embodiments, the un-patterned buffer cap layer **906** may comprise an oxide (e.g., an un-doped silicate glass), for example.

FIG. 10 illustrates some embodiments of a cross-sectional view **1000** corresponding to acts **512-514**.

As shown in cross-sectional view **1000**, an etch stop layer **212** is deposited onto the un-patterned buffer cap layer **906**. In some embodiments, the etch stop layer **212** may comprise a silicon nitride film formed by a PE-CVD deposition (a PE-SiN layer) process or a silicon oxy-nitride film formed by a PE-CVD deposition (a PE-SiON layer), for example. In some embodiments, the etch stop layer **212** may be deposited by way of a vapor deposition process (e.g., physical vapor deposition, chemical vapor deposition, etc.).

A bottom electrode etching process is subsequently performed by selectively exposing the un-patterned buffer cap layer **906**, the capacitor dielectric layer **604**, and the CBM layer **602** to an etchant **1002**. The etchant **1002** defines a capacitor bottom metal (CBM) **202** (i.e., a bottom electrode of the MIM capacitor) by removing portions of the CBM layer **602**. In some embodiments, the etchant **1002** may comprise a dry etchant (e.g., a plasma etchant, an RIE etchant, etc.).

FIG. 11 illustrates some embodiments of a cross-sectional view **1100** corresponding to act **516**.

As shown in cross-sectional view **1100**, an upper capacitor inter-level dielectric (ILD) layer **1102** is formed onto the MIM capacitor **201**. In various embodiments, the upper capacitor ILD layer **1102** may comprise a low-k dielectric material, an oxide material, etc. The upper capacitor ILD layer **1102** may be deposited by way of a vapor deposition technique (e.g., PVD, CVD, etc.).

FIG. 12 illustrates some embodiments of a cross-sectional view **1200** corresponding to acts **518-522**.

As shown in cross-sectional view **1200**, a planarization process may be performed to form a planar surface on top of the upper capacitor ILD layer **1102**. A planar etch stop layer **220** is then formed over the upper capacitor ILD layer **1102**. A first metal via **224a** and a second metal via **224b** are then formed to electrically connect metal wires, **226a** and **226b**, to the CTM **206** and the CBM **202**, respectively. The first and second metal vias, **224a** and **224b**, may be formed by depositing a metal ILD layer **222** over the planar etch stop layer

220. A via etching process (e.g., a dry etching process) is performed to form openings that extend from a top of the metal ILD layer **222** to the CTM **206** and the CBM **202**. A metal (e.g., copper, tungsten, aluminum, etc.) is then deposited within the openings to form the first and second vias, **224a** and **224b**.

FIG. **13** illustrates a flow diagram of some embodiments of a method **1300** of forming an MIM structure comprising a resistive random access memory (RRAM) cell having a buffer cap layer.

At **1302**, a lower metal interconnect layer is formed within a lower inter-level dielectric (ILD) layer overlying a semiconductor substrate. In some embodiments, the lower metal interconnect layer may comprise a copper metal layer formed using a damascene process.

At **1304**, a lower metal layer is deposited and patterned to form a lower electrode of the RRAM cell over the lower metal interconnect layer. The lower electrode may comprise tantalum (Ta), tantalum nitride (TaN), titanium (Ti), titanium nitride (TiN), deposited by way of a physical vapor deposition technique (e.g., CVD, PVD, etc.).

At **1306**, a dielectric data storage layer having a variable resistance is formed over the lower electrode. In some embodiments, the dielectric data storage layer may comprise a hafnium oxide layer (HfO) deposited by way of a physical vapor deposition technique.

At **1308**, a capping layer may be formed over the dielectric data storage layer. The capping layer is configured to store oxygen. In some embodiments, the capping layer may comprise a metal such as titanium (Ti), hafnium (Hf), platinum (Pt), ruthenium (Ru), and/or aluminum (Al). In other embodiments, the capping layer may comprise a metal oxide such as titanium oxide (TiO_x), hafnium oxide (HfO_x), zirconium oxide (ZrO_x), germanium oxide (GeO_x), cesium oxide (CeO_x).

At **1310**, an upper metal layer is deposited over the capping layer. The upper conductive layer may comprise tantalum (Ta), tantalum nitride (TaN), titanium (Ti), titanium nitride (TiN), deposited by way of a physical vapor deposition technique (e.g., CVD, PVD, etc.).

At **1312**, a buffer cap layer is formed over the upper metal layer. In some embodiments, the buffer cap layer may comprise an oxide layer (e.g., an un-doped silicate glass).

At **1314**, a masking layer is formed onto the buffer cap layer. The masking layer defines an upper electrode of the RRAM cell. In some embodiments, the masking layer may comprise a silicon oxy-nitride (SiON) hard mask layer, a silicon dioxide (SiO₂) hard mask layer, or a PE-SiN hard mask

At **1316**, the buffer cap layer and the upper metal layer are patterned according to the masking layer. Patterning of the upper conductive layer results in the formation of an upper electrode of the RRAM cell.

At **1318**, a top dielectric layer is formed over the masking layer. In some embodiments, the top dielectric layer continuously extends from position abutting the masking layer to position abutting the dielectric data storage layer. In various embodiments, the top dielectric layer may comprise silicon nitride (SiN) or silicon carbide (SiC), for example.

At **1320**, an upper inter-level dielectric (ILD) layer is formed over the top dielectric layer. In various embodiments, the upper capacitor ILD layer may comprise a low-k dielectric material, an oxide material, etc

At **1322**, an upper metal interconnect layer is formed onto the upper electrode. The upper metal interconnect layer com-

prises an upper metal via formed at a position in contact with the upper electrode, and an upper metal wire formed in contact with the upper metal via.

Therefore, the present disclosure relates to a method of forming a MIM (metal-insulator-metal) structure having a buffer cap layer that is configured to reduce stress induced by an overlying stress-inducing protective layer, and an associated apparatus.

In some embodiments, the present disclosure relates to a method of forming a MIM (metal-insulator-metal) structure. The method comprises forming a lower conductive layer over a semiconductor substrate, forming a dielectric layer over the lower conductive layer, and forming an upper conductive layer over the dielectric layer. The method further comprises forming a buffer cap layer over the upper conductive layer. The method further comprises forming a stress-inducing protective layer onto the buffer cap layer, wherein the buffer cap layer is configured to reduce a stress induced onto the upper conductive layer by the stress-inducing protective layer.

In other embodiments, the present disclosure relates to a method of forming a MIM (metal-insulator-metal) structure. The method comprises forming a lower conductive layer over a semiconductor substrate. The method further comprises depositing an un-patterned upper conductive layer at a position separated from the lower conductive layer by a dielectric layer, and patterning the un-patterned upper conductive layer according to a masking layer to form an upper conductive layer. The method further comprises performing a post patterning treatment to form an oxide interface layer on side-walls of the upper conductive layer. The method further comprises forming a buffer cap layer comprising an un-doped silicate glass (USG) in-situ with the post patterning treatment. The method further comprises forming a stress-inducing protective layer onto the buffer cap layer, wherein the buffer cap layer is configured to reduce a stress induced onto the upper conductive layer by the stress-inducing protective layer.

In yet other embodiments, the present disclosure relates to a MIM (metal-insulator-metal) structure. The MIM structure comprises a bottom conductive layer disposed over a semiconductor substrate, a dielectric layer disposed over the bottom conductive layer, and an upper conductive layer over the dielectric layer. The MIM structure further comprises a buffer cap layer over the upper conductive layer. The MIM structure further comprises a stress-inducing protective layer onto the buffer cap layer, wherein the buffer cap layer is configured to reduce a stress induced onto the upper conductive layer by the stress-inducing protective layer.

The foregoing outlines features of several embodiments so that those skilled in the art may better understand the aspects of the present disclosure. Those skilled in the art should appreciate that they may readily use the present disclosure as a basis for designing or modifying other processes and structures for carrying out the same purposes and/or achieving the same advantages of the embodiments introduced herein. Those skilled in the art should also realize that such equivalent constructions do not depart from the spirit and scope of the present disclosure, and that they may make various changes, substitutions, and alterations herein without departing from the spirit and scope of the present disclosure.

What is claimed is:

1. A method of forming a MIM (metal-insulator-metal) structure, comprising:
 - forming a lower conductive layer over a semiconductor substrate;
 - forming a dielectric layer over the lower conductive layer;
 - forming an upper conductive layer over the dielectric layer;

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forming a buffer cap layer over the upper conductive layer;
and
forming a stress-inducing protective layer vertically
arranged between the buffer cap layer and a dielectric
material laterally surrounding a metal via layer that ver-
tically extends through the stress-inducing protective
layer, wherein the buffer cap layer is configured to
reduce a compressive stress induced onto the upper con-
ductive layer by the stress-inducing protective layer.

2. The method of claim 1, further comprising:
forming an oxide interface layer onto sidewalls of the
upper conductive layer, wherein the oxide interface
layer prevents a presence of a metallic polymer residue
on the sidewalls of the upper conductive layer, which
results from patterning of the upper conductive layer.

3. The method of claim 2, wherein forming the oxide
interface layer, comprises:
introducing one or more oxygen-containing first gases into
a processing chamber, wherein the one or more oxygen-
containing first gases form the oxide interface layer onto
the sidewalls of the upper conductive layer.

4. The method of claim 3, wherein forming the buffer cap
layer, comprises:
introducing one or more second gases into the processing
chamber in-situ with introducing the one or more oxy-
gen-containing first gases, wherein the one or more oxy-
gen-containing first gases and the one or more second
gases collectively act to form the buffer cap layer by way
of a chemical vapor deposition (CVD) process.

5. The method of claim 1, wherein the stress-inducing
protective layer includes a PE-SiN or PE-SiON layer com-
prising a silicon nitride or a silicon oxy-nitride film formed by
a plasma enhanced chemical vapor deposition (PE-CVD)
process.

6. The method of claim 1, wherein the buffer cap layer
comprises an un-doped silicate glass.

7. The method of claim 1, wherein forming the dielectric
material comprises:
depositing an upper inter-level dielectric (ILD) layer over
the stress-inducing protective layer;
performing a planarization process on the upper ILD layer
to form a planar surface; and
forming a planar etch stop layer onto the planar surface.

8. The method of claim 1,
wherein the dielectric layer comprises a dielectric data
storage layer having a variable resistance; and
wherein the buffer cap layer comprises a planar layer hav-
ing sidewalls aligned with sidewalls of the upper con-
ductive layer.

9. The method of claim 1, wherein the stress-inducing
protective layer has a sidewall that is laterally aligned with a
sidewall of the dielectric layer.

10. The method of claim 1, wherein the metal via layer
vertically extends through the stress-inducing protective
layer from the upper conductive layer to an overlying metal
wire layer surrounded by a metal ILD layer over the dielectric
material.

11. The method of claim 1, wherein the upper conductive
layer laterally contacts the buffer cap layer.

12. The method of claim 1, wherein the lower conductive
layer laterally contacts the dielectric material.

13. A method of forming a MIM (metal-insulator-metal)
structure, comprising:
forming a lower conductive layer over a semiconductor
substrate;

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depositing an un-patterned upper conductive layer at a
position separated from the lower conductive layer by a
dielectric layer;
patterning the un-patterned upper conductive layer accord-
ing to a masking layer to form an upper conductive layer;
performing a post patterning treatment to form an oxide
interface layer on sidewalls of the upper conductive
layer;
forming a buffer cap layer comprising an un-doped silicate
glass (USG) in-situ with the post patterning treatment;
and
forming a stress-inducing protective layer onto the buffer
cap layer, wherein the stress-inducing protective layer
has a sidewall that is laterally aligned with a sidewall of
the dielectric layer, and wherein the buffer cap layer is
configured to reduce a compressive stress induced later-
ally onto the upper conductive layer by the stress-induc-
ing protective layer.

14. The method of claim 13, wherein performing the post
patterning treatment, comprises:
introducing one or more oxygen-containing first gases into
a processing chamber, wherein the one or more oxygen-
containing first gases form the oxide interface layer onto
the sidewalls of the upper conductive layer.

15. The method of claim 14, wherein forming the buffer
cap layer, comprises:
introducing one or more second gases into the processing
chamber in-situ with introducing the one or more oxy-
gen-containing first gases, wherein the one or more oxy-
gen-containing first gases and the one or more second
gases collectively act to form the buffer cap layer by way
of a chemical vapor deposition (CVD) process.

16. The method of claim 13, wherein the stress-inducing
protective layer includes a PE-SiN or PE-SiON layer com-
prising a silicon nitride or a silicon oxy-nitride film formed by
a plasma enhanced chemical vapor deposition (PE-CVD)
process.

17. The method of claim 13,
wherein the dielectric layer comprises a high-k dielectric
layer having a dielectric constant that is greater than 3.9;
and
wherein the buffer cap layer comprises a stepped layer that
abuts sidewalls of the upper conductive layer.

18. A MIM (metal-insulator-metal) structure, comprising:
a bottom conductive layer disposed over a semiconductor
substrate;
a dielectric layer disposed over the bottom conductive
layer;
an upper conductive layer disposed over the dielectric
layer;
a buffer cap layer disposed over the upper conductive layer;
and
a stress-inducing protective layer vertically arranged
between the buffer cap layer and a dielectric material
laterally surrounding a metal via layer that vertically
extends through the stress-inducing protective layer,
wherein the buffer cap layer is configured to reduce a
compressive stress laterally induced onto the upper con-
ductive layer by the stress-inducing protective layer.

19. The MIM structure of claim 18, wherein the stress-
inducing protective layer includes a PE-SiN layer comprising
a silicon nitride film formed by a plasma enhanced chemical
vapor deposition (PE-CVD) process.

20. The MIM structure of claim 18, wherein the buffer cap
layer comprises an un-doped silicate glass.